

Work Order ID 77810

Wednesday, December 21, 2011 1:10:37 PM

77810

Page 1

Item ID: D3296-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Assembly
 Start Date: 12/21/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/30/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: *mf* Date: *11-12-21* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3296	Rev A								

100
100
 Small Fab
 Small Fab
 Small Fab
 Memo
 Fabricate & assemble as per Dwg D3296.
 Transfer drill using DT8470 & DT9521
 0.00
 0.00

110
110
 QC
 Quality Control
 Memo
 QC5- Inspect part completeness to step on W/O
 0.00
 0.00

120
120
 Powdercoat
 Powder Coating
 Memo
 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3
 0.00
 0.00

START TIME: *10:00* OVEN TEMPERATURE:
 FINISH TIME: *10:30*

m115128

3200F

10:30

12/02/01 *(4)*

(x4)

4X M-12/02/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3296								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

H BL 1223.

12/22/06 (4)

8 12/22/06

(20)

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location <u>210</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/21/11 1:10:37 PM

M.C.J. 12/02/08

4

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Picklist Print

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Work Order ID: 77810

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 12/21/2011

Required Date: 12/30/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C05.10.14Added step 14KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2137 Decal - No Step		Manufactured	No			140	Each	22.0000	1	4		12/22/06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		22							
				72053		2							
				76064		20							
D2419 Handle		Manufactured	No			140	Each	6.0000	1	4		12/22/06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		6							
				76080		6							
D2462 Seal		Manufactured	No			140	f	410.0000	0.3333	1.3332		12/22/06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST404		410							
				48530		410							
D2728-1 Dart Logo label		Manufactured	No			140	Each	0.0000	0	0		12/22/06	
D3161-7 Hinge 14.0"		Manufactured	No			100	Each	7.0000	1	4		12/01/31	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		7							
				76938		7							
D3161-9 Hinge 17.0"		Manufactured	No			100	Each	6.0000	1	4		12/01/31	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		6							
				76939		6							

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Parent Item Name: Door Assembly

Start Date: 12/21/2011

Required Date: 12/30/2011

Start Qty: 4.00

Required Qty: 4.00

D3296-1
Door Panel

Manufactured No

100 Each 18.0000

1

4

Location

Loc Qty

Loc Code

ST186

18

74614

2

75064

16

D3296 3

Door Panel

Manufactured No

100 Each 22.0000

1

4

Location

Loc Qty

Loc Code

ST186

22

74615

6

75061

16

MS20470AD4-4

Rivet, Universal Head

Purchased No

140 Each 3,928.0000

25

100

Location

Loc Qty

Loc Code

ST319

3928

116188

136

116391

66

118614

1190

119109

2000

119386

536

MS20470AD4-6

Rivet, Universal Head

Purchased No

100 Each 2,729.0000

1

4

Location

Loc Qty

Loc Code

ST319

2729

117395

28

118927

701

119109

1000

119546

1000

NAS1149DN632J

Washer

Purchased No

140 Each 695.0000

1

4

Location

Loc Qty

Loc Code

ST298

695

118428

695

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Shop Packet Print

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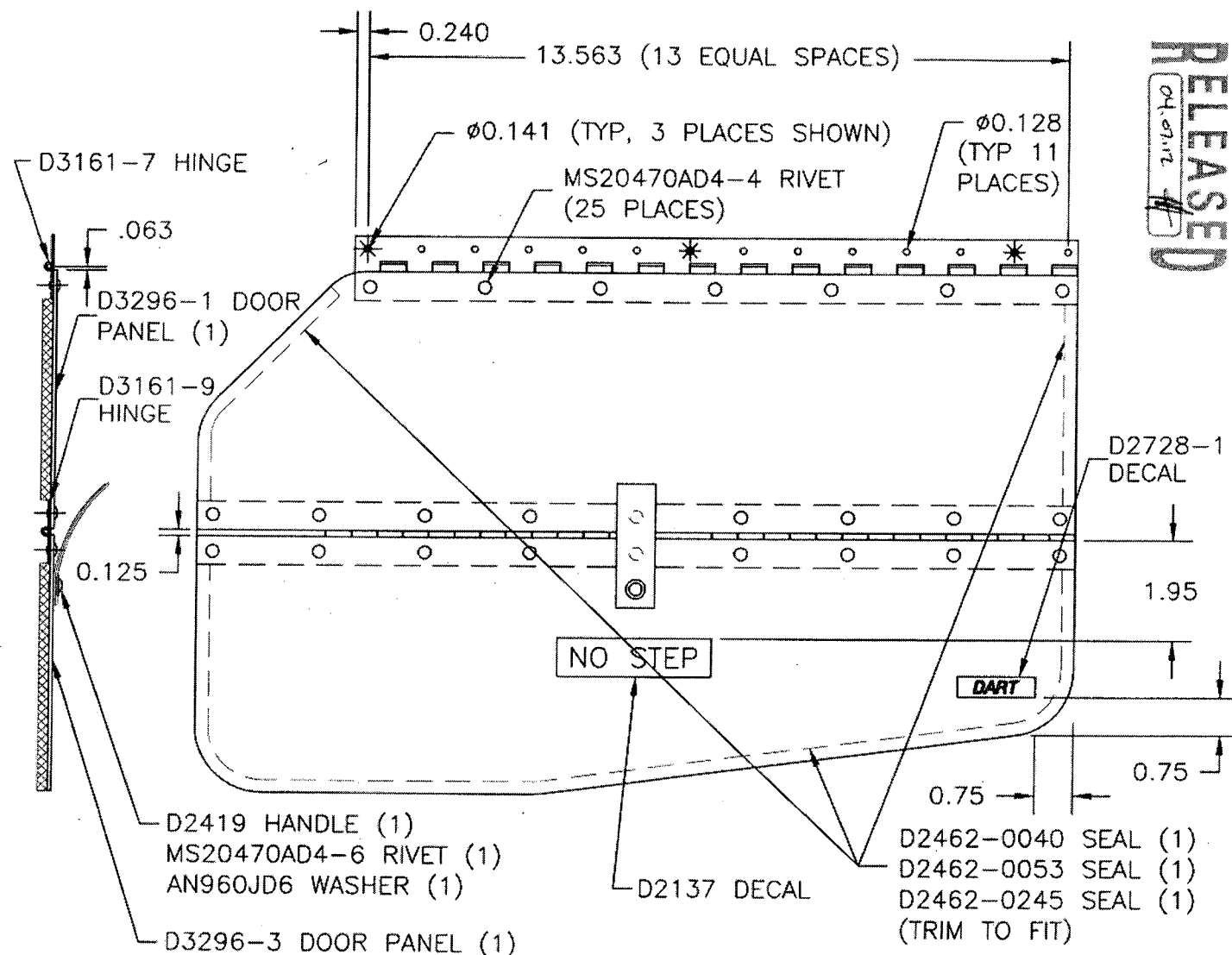
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3296	1 OF 2
04.06.28		TITLE	SCALE
		DOOR ASSEMBLY	1:3
A	04.06.28	NEW ISSUE	

RELEASED
04.01.12



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

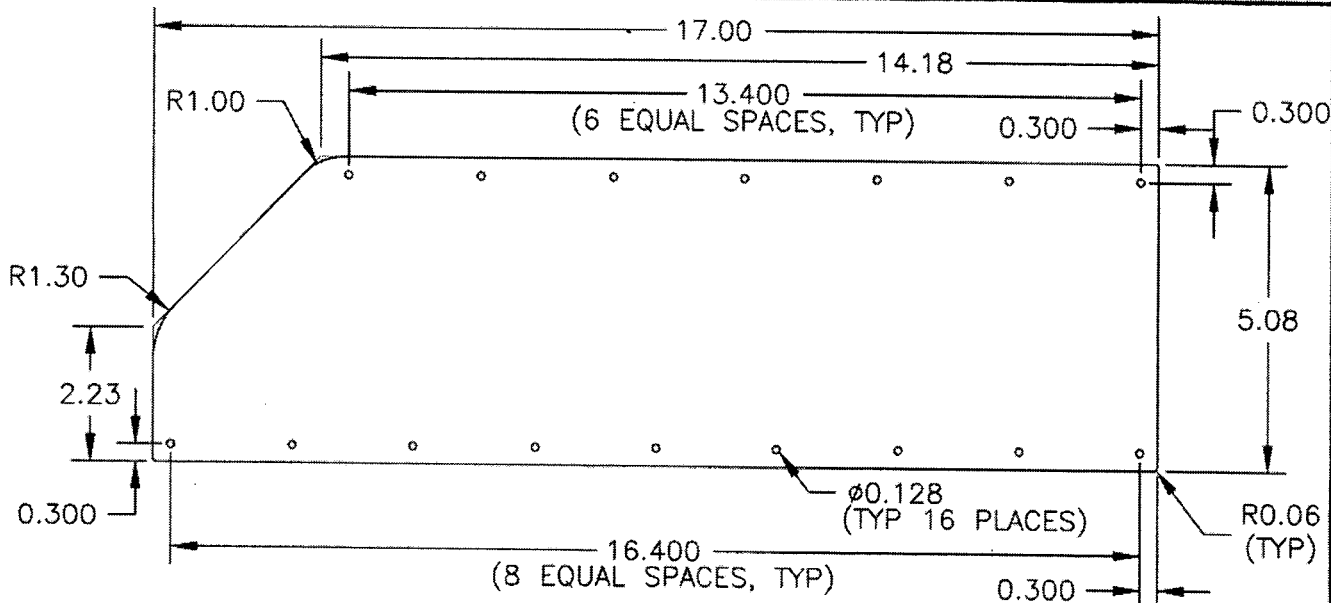
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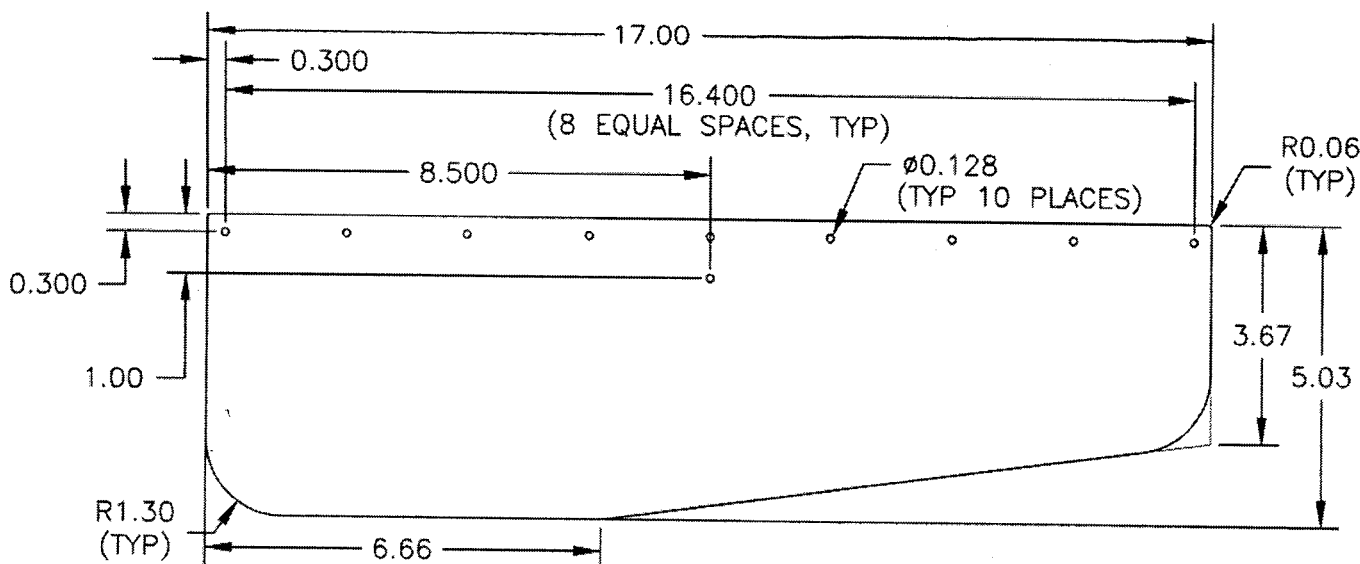
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12 *#*

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